

Work Order ID 113205

February-12-14 8:58:09 AM

113205

Page 1

Item ID: D2712 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Set Screw
 Start Date: 2/10/14 Start Qty: 200.00 *200* Cust Item ID:
 Required Date: 2/10/14 Req'd Qty: 200.00 *200* Customer:
 Reference:

Approvals: Process Plan: MF Date: 14-02-14 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2712 | Rev B | | | | | | | | |
| 100 | PURCHASING | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Purchasing | Memo | 0.00 | | | | | | | |
| Purchasing | Issue P/O: <u>23067</u> For Hex Head Set Screw P/N: <u>92311A599</u> as per Dwg D2712 Thread: 5/16-24UNF Length: 5/8" long SSPossible Supplier: McMaster Material release note is required | | | | | | | | <u>CZ 14/02/14 200</u> |
| 110 | Receive & Inspect for Damage & Mat'l Certs | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Ensure material release note is attached | | | | | | | | <u>P 14/4/21 (200)</u> |
| 120 | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | <u>200</u> |

DAS
27
9-89

14/2/21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|--|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence |
| | | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

February-12-14 8:58:09 AM

Page 2

[illegible]

14-02-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | |
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| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
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| Unapproved | | | | | | | | | |

FAULT CATEGORY

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|--|--|---|---|

Picklist Print

Page 1

February-12-14 8:58:13 AM

Work Order ID: 113205

113205

Parent Item: D2712

D2712

Parent Item Name: Set Screw

Start Date: 2/10/14

Required Date: 2/10/14

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP: C05.09.13ReformatKJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| 92311A599 | | Purchased | No | | | 100 | Each | 0.0000 | 1 | 200 | | | |
| *92311A599* | | | | | | | | | | ** | | | |
| SET SCREW | | | | | | | | | | | | | |

P 1/4/2/21 (200)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
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| Handling/Pre <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Offset/Setup <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Transport <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

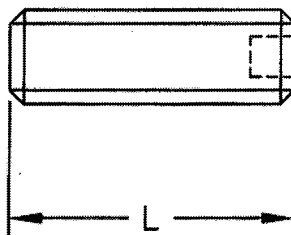
FAULT CATEGORY

| | | |
|--|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence |
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| | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |



| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN DS | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2712 | REV. B SHEET 1 OF 1 |
| DATE 05.05.04 | | TITLE SET SCREW | SCALE NTS |
| A | 97.11.03 | NEW ISSUE | |
| B | 05.05.04 | MATERIAL NOW SS ONLY | |

RELEASED
05-09-06



D2712 SET SCREW

- 1) TYPE: HEX SOCKET HEAD SET SCREW
- 2) THREAD: 5/16"-24 (UNF)
- 3) LENGTH: L = 5/8" TO 3/4"
- 4) MATERIAL: STAINLESS STEEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 113205 MP
14-02-14

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO23067

Purchase Order Date 2/19/2014

PO Print Date 2/19/2014

Page Number 2 of 5

| | | | |
|--------------------------|-----------|------------------------|--------------------|
| Order From : | VU-MCM001 | Ship To : | DART AEROSPACE LTD |
| MCMaster-CARR SUPPLY CO, | | 1270 ABERDEEN | |
| P.O. BOX 7690 | | HAWKESBURY, ON K6A 1K7 | |
| CHICAGO, IL 60680-7690 | | CANADA | |
| US | | | |

Contact Name
Vendor Phone 330 995 5500

Ship To Contact
Ship To Phone

Ship Via FedEx PI collect
Ship Acct

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency USD
FOB FCA - (Free Carrier)

| | | | | | | | |
|---|-----------|----------------|-----------|-------|--------|----------|------------|
| 3 | 97787A661 | Expandable Pin | 2/20/2014 | 30.00 | NEC 5 | \$114.68 | \$3,440.40 |
| | | | Yes | Each | NEC 25 | | |
| | | | 3/20/2014 | | | | |

AS PER DWG D4711 REV. C
B113418

Line Total: \$3,440.40

| | | | | | | | |
|---|-----------|-----------|-----------|--------|--|--------|---------|
| 4 | 92311A599 | SET SCREW | 2/20/2014 | 200.00 | | \$0.22 | \$43.20 |
| | | | Yes | Each | | | |
| | | | 3/20/2014 | | | | |

AS PER DWG D2712 REV. B
B113205

Line Total: \$43.20

| | | | | | | | |
|---|-----------|--------|-----------|--------|--|--------|---------|
| 5 | 95606A170 | Washer | 2/20/2014 | 100.00 | | \$0.10 | \$10.14 |
| | | | Yes | Each | | | |
| | | | 3/20/2014 | | | | |

AS PER DWG D3631 REV. A
B113164

Line Total: \$10.14

PO Instructions: Procurement Quality Clauses
A005 right of entry
A026 certification of material conformance
A040 notification of quality escape

Note:

2/19/2014

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.comDart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
CanadaOrder Placed By
Chantal Lavoie

02/19/2014

McMaster-Carr Number
8113645-02

| Line | Description | Ordered | Shipped |
|------|---|------------|---------|
| 1 | 91249A146 Black-Oxide Finish Pan Head Phillips Machine Screw, 18-8 Stainless Steel, 6-32 Thread, 3/8" Length, Packs of 100 Your Part Number: B113458 Unit Price: \$5.40 Extended Price: \$5.40 | 1 Pack | 1 |
| 2 | 91525A120 Type 316 Stainless Steel Large-Diameter Flat Washer, 1/4" Screw Size, 1" OD, .04"-.06" Thick, Packs of 25 Your Part Number: B113216 Unit Price: \$6.66 Extended Price: \$26.64 | 4 Packs | 4 |
| 3 | 97787A661 Expanding Diameter Quick-Release Pin, 1/4" Diameter, 1" Usable Length Your Part Number: B113418 Unit Price: \$114.68 Extended Price: \$2,867.00 | 30 Each | 25 |
| 4 | 92311A599 18-8 Stainless Steel Cup Point Set Screw, 5/16"-24 Thread, 5/8" Long, Packs of 50 Your Part Number: B113205 Unit Price: \$10.80 Extended Price: \$43.20 | 4 Packs | 4 |
| 5 | 95606A170 Nylon 6/6 General Purpose Flat Washer, Off-White, 7/16" Screw Size, .69" OD, .02"-.04" Thickness, Packs of 100 Your Part Number: B113164 Unit Price: \$10.14 Extended Price: \$10.14 | 1 Pack | 1 |
| 6 | 98606A010 Alloy Steel Cup Point Set Screw Assortment, 200 Pieces, 12 Sizes in a Compartmented Plastic Box Your Part Number: 71500-30 Unit Price: \$44.29 Extended Price: \$88.58 | 2 Each | 2 |
| 7 | 97395A452 Corrosion Resistant Dowel Pin, Type 316 Stainless Steel, 1/8" Diameter, 1" Length, Packs of 10 Your Part Number: 71500-30 Unit Price: \$9.79 Extended Price: \$9.79 | 1 Pack | 1 |
| 8 | 5644K14 Assemble-Your-Own Retracting Air Hose, 5/16" ID, 3/8" OD, 210 PSI, Red, 100' Length Your Part Number: 71500-15 Unit Price: \$74.74 Extended Price: \$74.74 | 1 Each | 1 |
| 9 | 5644K54 Brass Male 360 Degree Easy-Install Body for 5/16" ID, Assemble-Your-Own Retracting Air Hose Your Part Number: 71500-45 Unit Price: \$7.80 Extended Price: \$156.00 | 20 Each | 20 |